

Work Order ID 155184***155184***

Page 1

Item ID: D5350-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Beam Assembly

Start Date: 01/09/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/13/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5350	Rev C								
110		0.00							
110									
Small Fab	Memo	0.04							
Small Fab	ASSEMBLE AS PER DWG SEE NOTE 9 FOR TORQUE SPEC ON NUTS								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89DAS
16
9-89

Work Order ID 155184

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155184

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Item ID: D5350-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Beam Assembly
Start Date: 01/09/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 01/13/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

1 JAN 13 2017



Picklist Print

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Work Order ID: 155184

155184

Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C
16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09
DWG REV.c DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-11 *D2690-11* Lanyard Assembly		Manufactured	No				Each	0.0000		2	DAS 30 9-89		JAN 13 2017
D3917-3 *D3917-3* Washer		Manufactured	No				Each	69.0000		2	DAS 30 9-89		JAN 13 2017
				<u>Location</u>		<u>Loc Qty</u>							
				ST058		69							
					151081	16				2			
					152988	53							
D5346-3 *D5346-3* Bushing		Manufactured	No				Each	0.0000		4			JAN 13 2017
D5350-3 *D5350-3* Aft Beam		Manufactured	No				Each	0.0000		1	DAS 30 9-89		JAN 13 2017
D5350-5 *D5350-5* Adapter		Manufactured	No				Each	0.0000		1	DAS 30 9-89		JAN 13 2017

**** B 155218**

B 155097

B 155180

17/01/13 DAS 36 9-89

Picklist Print

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Work Order ID: 155184

155184

Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

AN310-4
AN310-4
Nut

Purchased No

Each 103.0000

68-6
03
SVD

JAN 13 2017

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

40

M135704

0

M136295

40

ST331

38

M135704

3

M135999

35

3
1

JAN 13 2017

AN4-20
AN4-20
Bolt

Purchased No

Each 0.0000

68-6
03
SVD

1
①

MS17984-C412

Purchased No

Each 6.0000

68-6
03
SVD

2

JAN 13 2017

MS17984-C412
Pin, Quick Release

Location

Loc Qty

Loc Code

ST315

6

m130358

1

m135297

5

2

MS24665-151
MS24665-151
Cotter Pin

Purchased No

Each 190.0000

68-6
03
SVD

1

JAN 13 2017

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

130

m135274

30

m136444

100

1

JAN 13 2017

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Shop Packet Print

Picklist Print

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Work Order ID: 155184

155184

Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

Each

3,949.000

**

DAS
30
9-89

2

JAN 13 2017

NAS1149D0416.I

WASHER

Location

Loc Qty

Loc Code

GA

7

m131511

7

ST260a

2492

m131511

2492

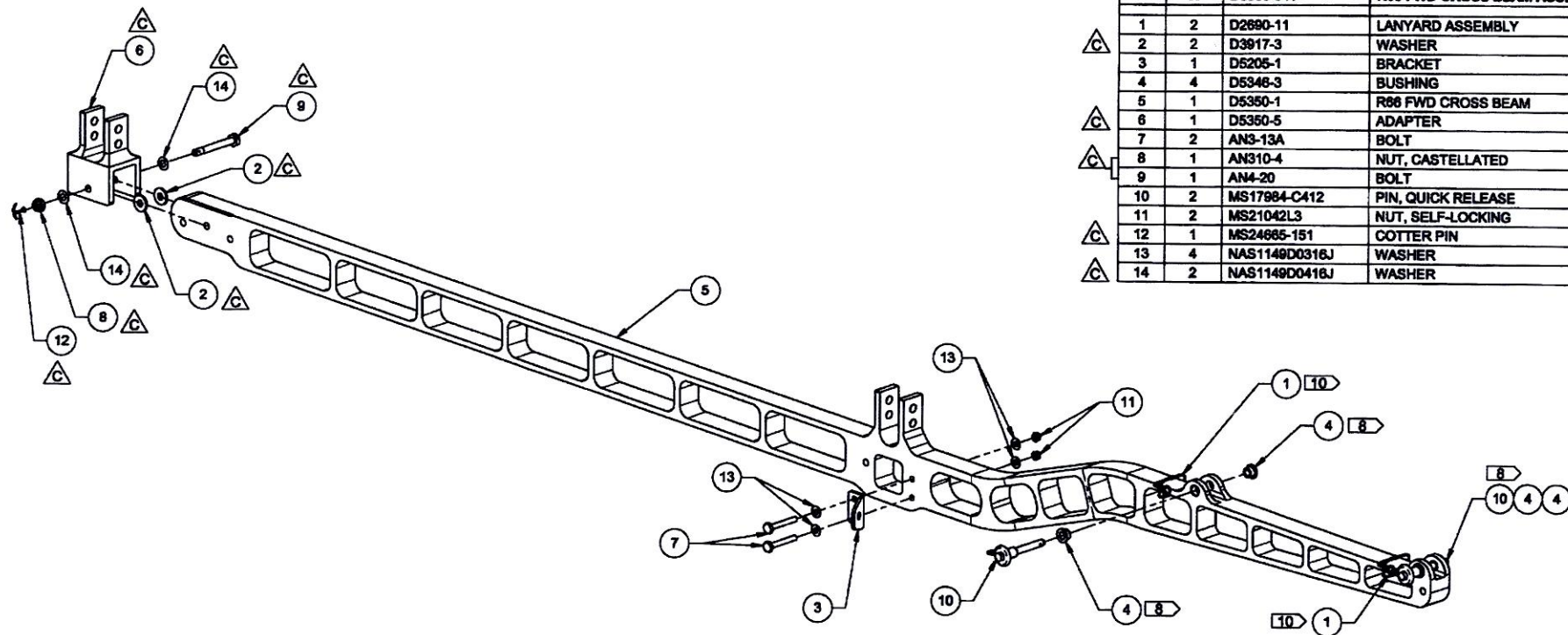
ST264

1450

m131511

1450

2



ITEM	QTY	P/N	DESCRIPTION
	X	D5350-041	R66 FWD CROSS BEAM ASSEMBLY
1	2	D2690-11	LANYARD ASSEMBLY
2	2	D3917-3	WASHER
3	1	D5205-1	BRACKET
4	4	D5346-3	BUSHING
5	1	D5350-1	R66 FWD CROSS BEAM
6	1	D5350-5	ADAPTER
7	2	AN3-13A	BOLT
8	1	AN310-4	NUT, CASTELLATED
9	1	AN4-20	BOLT
10	2	MS17984-C412	PIN, QUICK RELEASE
11	2	MS21042L3	NUT, SELF-LOCKING
12	1	MS24865-151	COTTER PIN
13	4	NAS1149D0316J	WASHER
14	2	NAS1149D0416J	WASHER

D5350-041 R66 FWD CROSS BEAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.96 lbs
- 8) PRESS FIT D5346-3 INTO D5350-1
- 9) TORQUE MS21042L3 NUTS TO 20-25 in-lb (2.3-2.8 N-m)
- 10) ASSEMBLE D2690-11 WITH MS17984-C412 AS SHOWN

C	REDESIGN -1/31-0411-043 (ZN A4-1, A4-2, A4-3, A4-4); ADDED -5 (ZN A4-5) & NOTE 10 & 11 (ZN A8-3, A8-4); REVISE BOM% ZN (D3-1, D3-2)	RF	16.11.18
B	REDESIGN -1/31-0411-043 (ZN A4-1, A4-2, A4-3, A4-4)	RF	16.05.24
A	NEW ISSUE	RF	16.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	WK		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	16.11.18		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

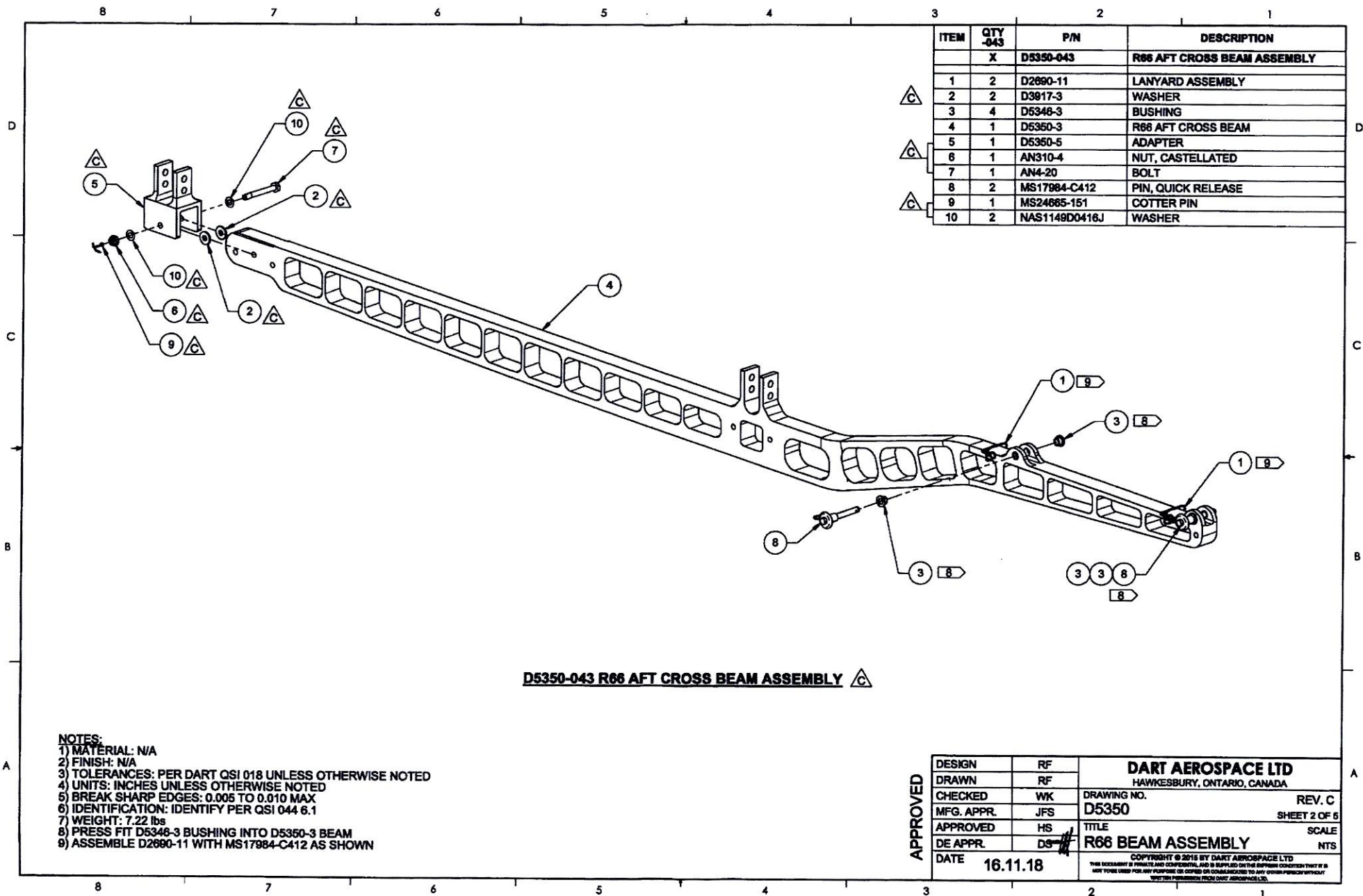
D5350

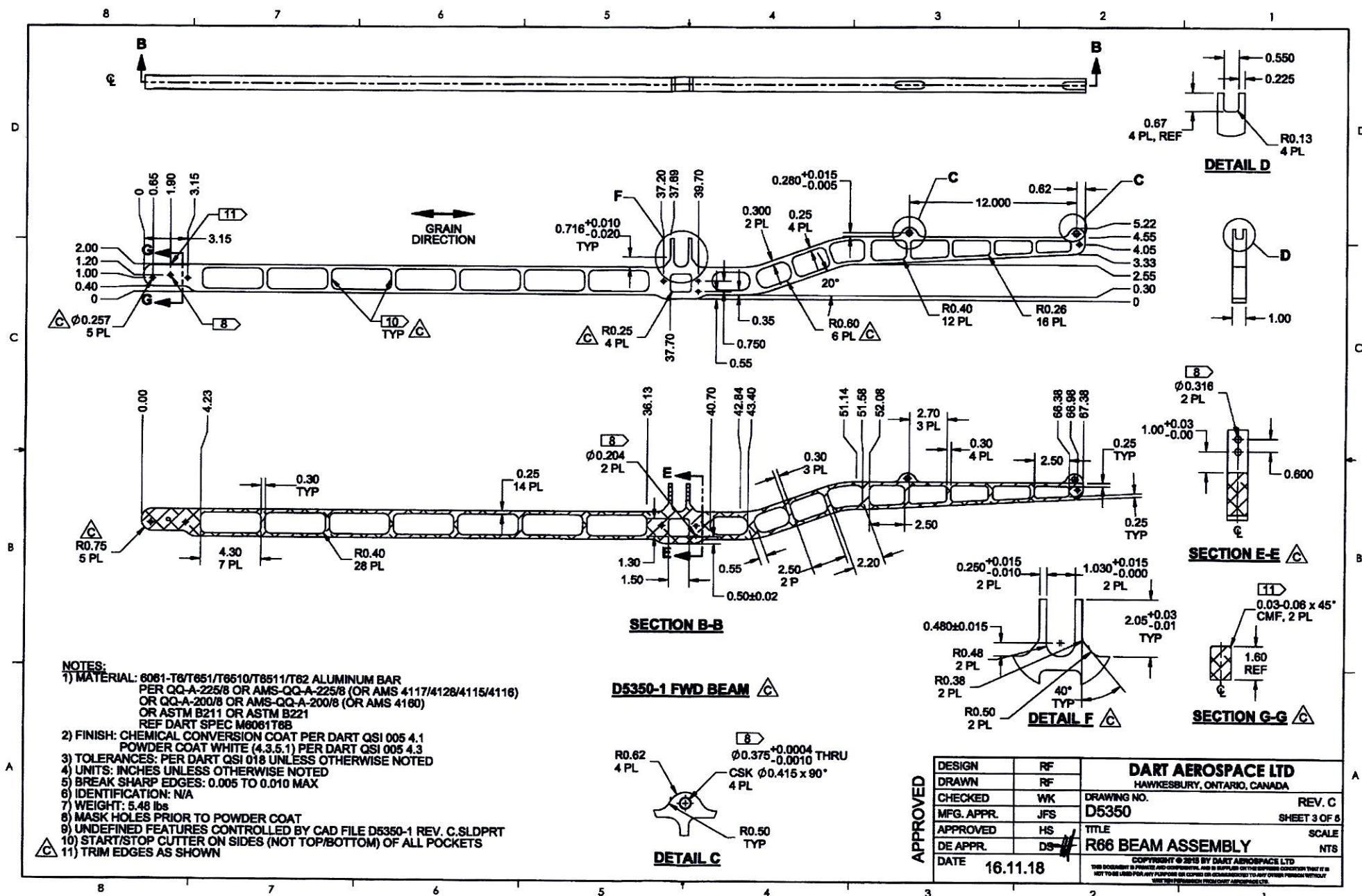
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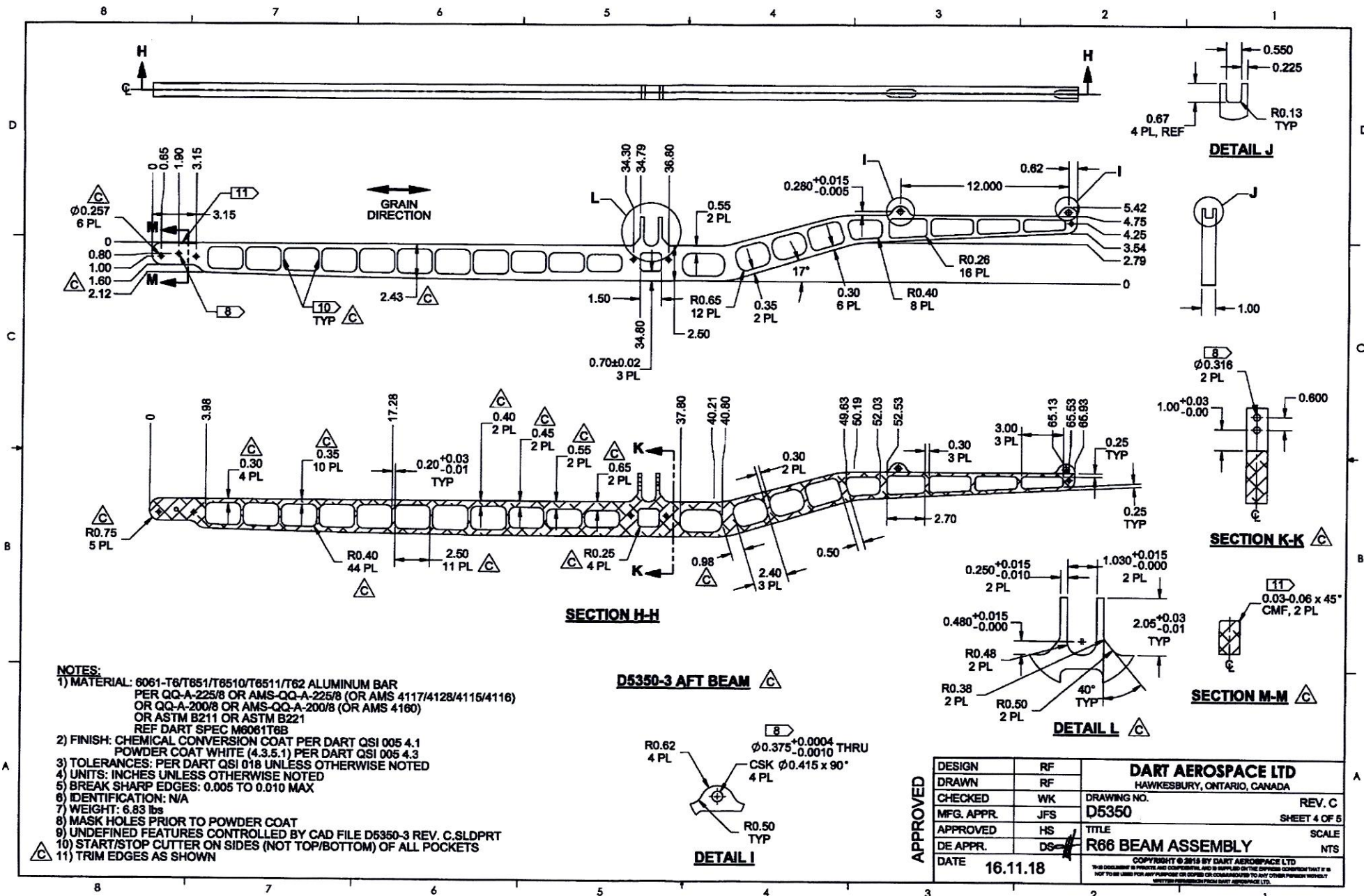
R66 BEAM ASSEMBLY

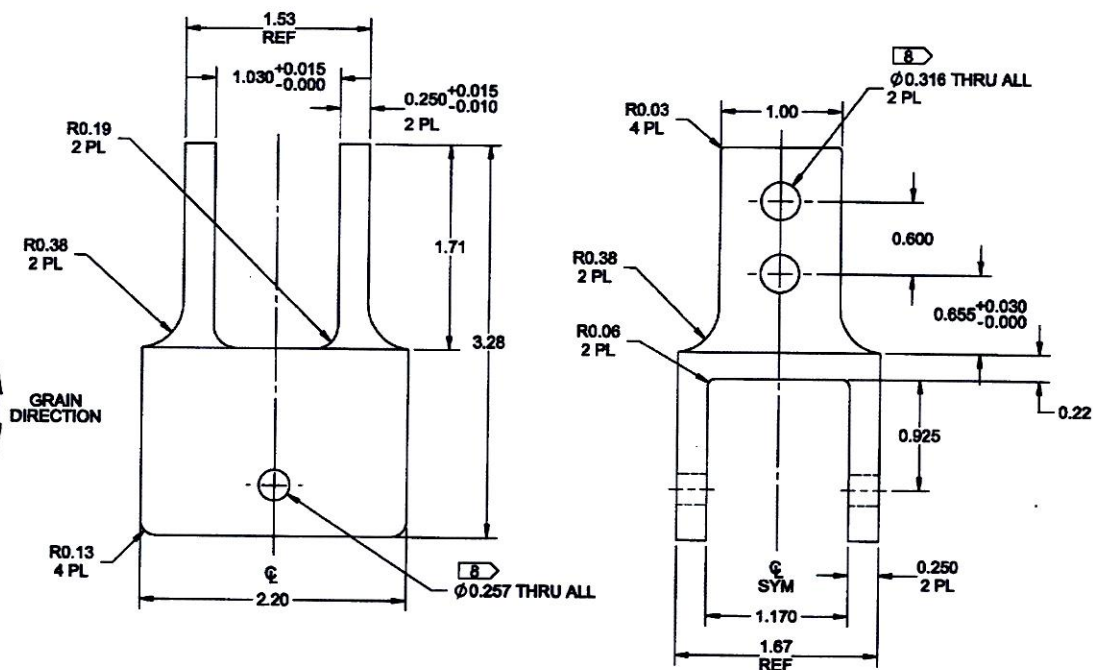
REV. C SHEET 1 OF 5 SCALE NTS

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D5350-5 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	WK	DRAWING NO. D5350	REV. C
	MFG. APPR.	JFS	SHEET 5 OF 6	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DSC	R66 BEAM ASSEMBLY	NTS
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